

# FOR TEST (AIRBORNE ROAD TEST)

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 23640
<b>Description:</b> Arm Weldment		<b>Part Number:</b> D3379-044
Dwg: D3379 Rev. A page 1		<b>Qty:</b> 4
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Remove D3379-043 / D3379-1 from inventory		05.06.21	4
2	MFA	Assemble and weld using welding Jig DT8764 as per Dwg D3379 Pick: + correct angle as per D3379 rev. C Qty Part Number Description Batch 1 D3379-043 Lever Assembly B22470 1 D3379-1 Support B22817 B22471 Identify as D3379-041		05/09/22	4
3	QC5/9	Inspect work to Step 2		05/08/22	4
4	FP	Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3 Mask holes		05.11.14	4
5	QC3	Inspect Powder Coat		05.11.14	4
6	ST	Identify and Stock Return to inventory for Airborne Road Test.		05.11.16	4
7	AC	Charge to project number P601-571/-572 Cost / part 99.53		05.11.21	4
8	DC	Close W/O 69.87 Inspect Level 21		05/11/21	4

Rev	Date	Change	Revised By	Approved
A	05.02.03	New issue	KJ/JLM	

PRELIMINARY ISSUE

UNDER REVIEW

05.06.02

CANCEL FOR

THIS W/O

05.06.21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

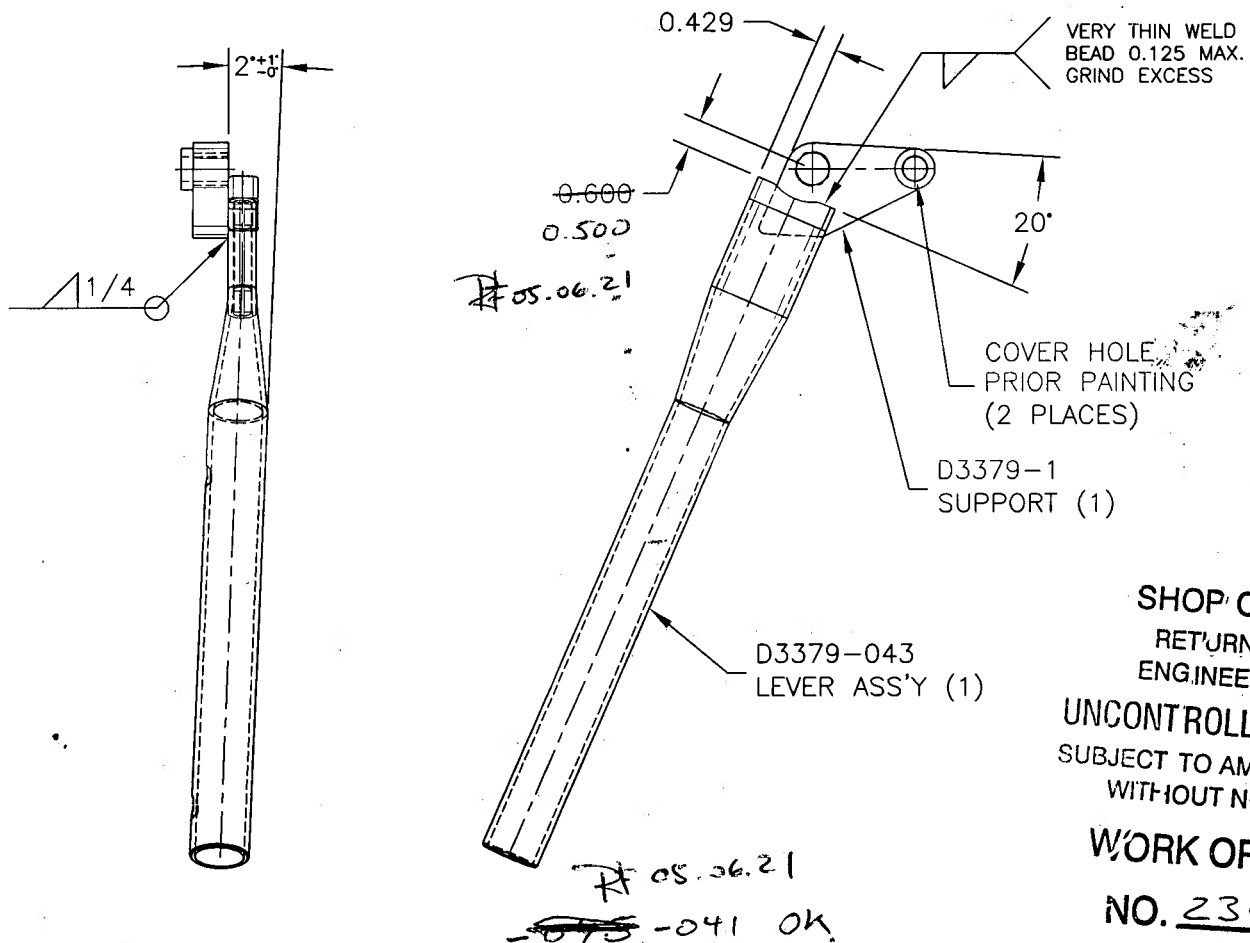
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:   D   Date: 05/11/21

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

DESIGN	DRAWN BY	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3379	REV. C SHEET 1 OF 4
DATE 05.05.27		TITLE ARM WELDMENT	SCALE 1:1
A	04.12.13	NEW ISSUE	
B	05.02.25	RE-DESIGN D3379-5	
C	05.05.27	2" WAS 4"	



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WITHOUT NOTICE  
WORK ORDER  
NO. 23640

### D3379-041 ARM WELDMENT

#### NOTES:

- 1) POSITION PARTS AS PER JIG D3379-041T1
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT FIRE RED (REF 4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

## PRELIMINARY ISSUE

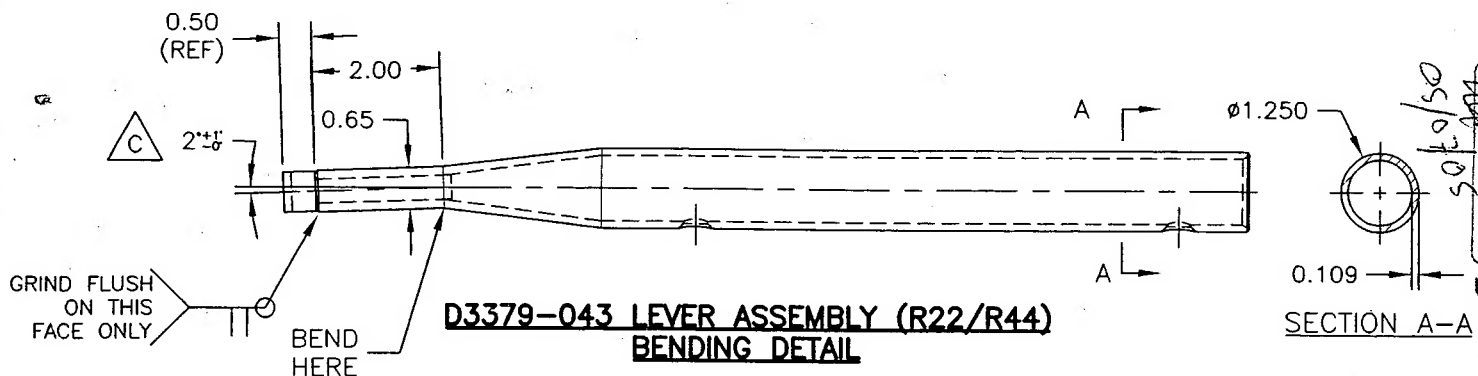
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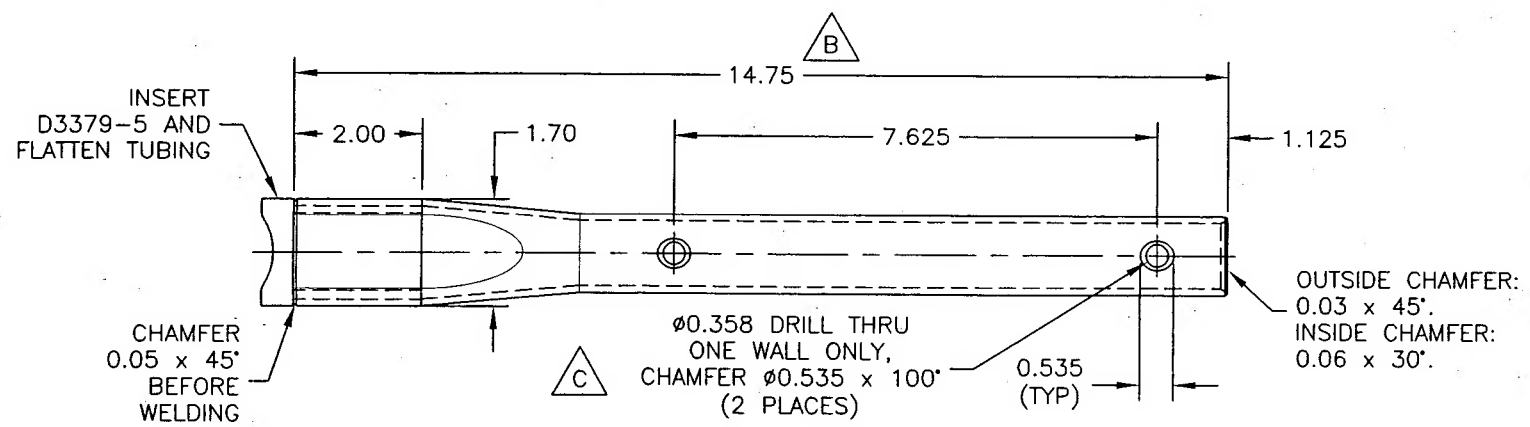




RELEASED  
05/09/05



**D3379-043 LEVER ASSEMBLY (R22/R44)**  
**BENDING DETAIL**



**D3379-3 LEVER (R22/R44)**

**NOTES:**

- 1) MATERIAL: 1018-1025 ROUND TUBING MILD STEEL SEAMLESS (REF. DART SPEC. M1018TR1.250W.109)
- 2) WELD PER QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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**WORK ORDER**

**NO. B23640**

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
DATE		D3379	SHEET 3 OF 4
05.05.27		TITLE	SCALE
		ARM WELDMENT	1:3



# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Nov 08, 2005  
10:32 am

Work Order No : 0023640  
Project Name : D3379-041  
Project For : WK526  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3379-041  
Description : Arm Weldment  
Manufactured : Yes  
Amount Req'd : 2  
Amount Done : 0  
Start Date : 06-21-05  
Est Finish Date :  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Margin : 0.000%  
Actual Margin : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	15.75	100.00		
Production Cost :	0.00	252.10	100.00	0.00	252.10
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	252.10	100.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	252.10			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	( -252.10)

MUS 21B  
u  
11-13

Date: Monday, 14/11/2005 8:52:31 AM  
 User: Alba Panzuto

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	ARM WELDMENT
<b>Job Number</b> :	23640		
<b>Estimate Number</b> :	10450		
<b>P.O. Number</b> :		<b>Part Number</b> :	D3379041
<b>This Issue</b> :	14/11/2005	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3379 REV C
<b>First Issue</b> :	/ /	<b>Project Number</b> :	
<b>Previous Run</b> :		<b>Drawing Revision</b> :	C
	<b>Type</b> :	<b>Material</b> :	
	LARGE FAB ASSY	<b>Due Date</b> :	30/11/2005
<b>Written By</b> :		<b>Qty:</b>	2
<b>Checked &amp; Approved By</b> :		<b>Um:</b>	Each
<b>Comment</b> :	Est A 05.02.03 New issue KJ/JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D3379043	Lever Assembly
2.0	D33791	Support
3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
<b>Comment:</b> LARGE FABRICATION RESOURCE 1 Assemble and weld using welding Jig DT8764 as per Dwg D3379 Identify as D3379-041		
4.0	QC5	INSPECT WORK TO CURRENT STEP
<b>Comment:</b> INSPECT WORK TO CURRENT STEP		
5.0	POWDER COATING	POWDER COATING
<b>Comment:</b> POWDER COATING Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3 Mask holes		
6.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
<b>Comment:</b> INSPECT POWDER COAT/CHEMICAL CONVERSION		
7.0	PACKAGING 1	PACKAGING RESOURCE #1
<b>Comment:</b> PACKAGING RESOURCE #1 Identify and Stock Location: _____		



Date: Monday, 14/11/2005 8:52:31 AM  
User: Alba Panzuto

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM WELDMENT

Job Number: 23640

Part Number: D3379041

Job Number:



Seq. #:

Machine Or Operation:

Description :

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion

